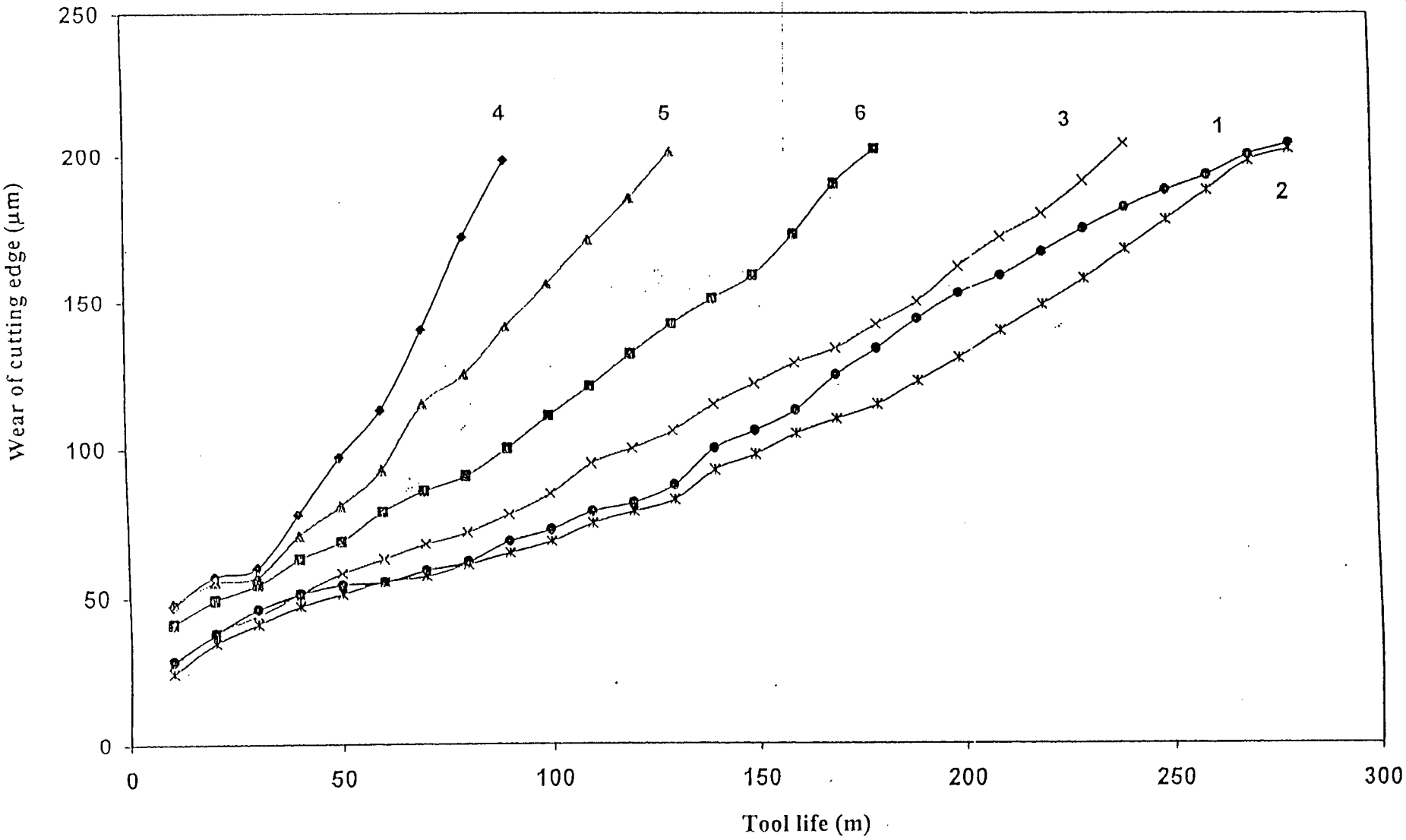
Fig. 1


250
200
150
100
50
0
0
50
100
150
200
250
300
Wear of cutting edge (µm)
Tool life (m)
4
5
6
3
1
2